

Work Order ID **102091-2**

**\*102091\***

Page 1

Item ID: D3179-041  
 Revision ID: ~~102091~~ N/A *R*  
 Item Name: Fwd Litter Tie Down  
 Start Date: 5/30/2013 Start Qty: ~~8.00~~ *6*  
 Required Date: 5/30/2013 Req'd Qty: 8.00  
 Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Cust Item ID:  
 Customer:

Approvals: Process Plan: *MF* Date: *13-5-23* Tooling:  
 QC: Date: SPC (Y/N):

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3179	Rev D

100	BAND SAW	0.00
<b>*100*</b>		
Bandsaw	Memo	0.00
Jeaspa Bandsaw	Cut blanks: 12.150" long	

*PD 13/05/29*  
*AS 13 05 30*  
*A*  
*Ø*

110	HAAS CNC VERTICAL MACHINING #1	0.00
<b>*110*</b>		
HAAS 1	Memo	0.00
HAAS CNC vertical machine #1	1- Mill as per Folio FA297 Rev: <i>AA</i> & Dwg D3179-1 Rev: <i>0</i> 2- Deburr per dwg D3179-1	

*PD 13/06/01*  
*8*  
*1*  
*13-05-31*  
*DA*  
*02*  
*BT*

120	QC2- Inspect parts off machine FAI/FAIB	0.00
<b>*120*</b>		
QC	Memo	0.00
Quality Control		

*PD*  
*8*  
*1*  
*13-05-31*  
*DA*  
*02*  
*BT*

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Item ID: D3179-041  
 Revision ID: U/R  
 Item Name: Fwd Litter Tie Down  
 Start Date: 5/30/2013 Start Qty: 8.00  
 Required Date: 5/30/2013 Req'd Qty: 8.00  
 Reference:

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:  
 Customer:

Approvals: Process Plan:  
 QC:

Date:  
 Date:

Tooling:

SPC (Y/N):

Date:  
 Date:

Run Start  
 Stop

\*NR1\*

\*NR2\*

Sequence ID/  
 Work Center ID

Operation  
 Description

Set Up/  
 Run Hours

Tool ID

Tool #

Plan  
 Code

Accept  
 Qty

Reject  
 Qty

Reject  
 Number

Insp.  
 Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Quality Control

Memo

0.00

13-6-3

8

DAS  
 04  
 9-80

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Hand Finishing

Memo

0.00

8 NG13 & 5

150

QC8- Inspect Part Finish

0.00

\*150\*

QC

Quality Control

Memo

0.00

8x 4 m.f 13/06/05



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Item ID: D3179-041  
Revision ID: U/R  
Item Name: Fwd Litter Tie Down  
Start Date: 5/30/2013 Start Qty: 8.00  
Required Date: 5/30/2013 Req'd Qty: 8.00  
Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Cust Item ID:  
Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/  
Work Center ID

160

\*160\*

Powdercoat

Powder Coating

W125620

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200-7-10

7-40

QC3- Inspect Part Finish

0.00

Memo

0.00

170

\*170\*

QC

Quality Control

Small Fab

0.00

Memo

Assemble as per Dwg D3179

0.00

180

\*180\*

Small Fab

Small Fab

Note: Accor to  
open up  $\phi 0.242$ " HOLES  
to  $\phi 0.240$ " -  $0.250$ "  
FOR INSTALLATION OF D2372  
PINS.

QSI 042

13.06.06

8x4 m/f 13/06/06

8x4 Ill v106/06

6  $\phi$  FF 13-06-06

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\*N900040100\*

Setup	Start	*NS1*
	Stop	*NS2*

\*8\*

\*8\*

**Customer:**

**Reference:**

Date:

Run Start \*NR1\*

Date:

Stop \*NR2\*

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC5- Inspect part completeness to step on W/O

6.00

\*190\*

0.00

QC

## Memo

### Quality Control

Identify as per dwg & Stock Location: ST221

0.00

\*200\*

0.00

### Packaging

## Memo

### Packaging

QC21- Final Inspection - Work Order Release

0.00

\*210\*

0.00

QC

## Memo

### Quality Control

13-67

6

6x

η.η. 13-06-6

13/6/10 

1213-047



# Picklist Print

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Page 1

Work Order ID: 102091  
Parent Item: D3179-041  
Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013

Required Date: 5/30/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF  
IPP Rev:B Added Powder Coat 07-07-04 JLM  
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0332J Washer		Purchased	No			100	Each	798.0000	3	24	FF	13-06-06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST293		360							
				125268		360				24			
				ST294		438							
				122973		68							
				125044		370							
D2372 Quick Release		Manufactured	No			180	Each	31.0000	2	16	FF	13-06-06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		31							
				101076		12				12			
				86001		2							
				97848		5							
				99810		12							
D2444 Pip Pin Assembly		Manufactured	No			180	Each	25.0000	1	8	FF	13-06-06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		25							
				101027		10							
				97238		1				1			
				98455		5							
				99370		4				2			
				99784		5				3			

# Picklist Print

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Work Order ID: 102091  
Parent Item: D3179-041  
Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 Required Date: 5/30/2013  
Start Qty: 8.00 Required Qty: 8.00

D6201 Manufactured No  
"T" Extrusion

180 f 47.9646 1.0125 8.5263158

PD 13/05/29

Location Loc Qty Loc Code

MAT028 47.96463153  
81421 4.61863153  
83987 20  
89645 3.346  
96808 20

x 4.05

3.1 END OF BATCH  
1.1 END OF BATCH

MS21042L3 Purchased No  
Nut

180 Each 3,403.0000

1 8

FF 13-06-06

Location Loc Qty Loc Code

FP001 3  
122141 3  
GA 18  
122452 18  
ST314 268  
117885 32  
119017 55  
119075 138  
123265 43  
ST506 3114  
123900 954  
124291 2160

180 Each 944.0000

1 8

FF 13-06-06

MS27039-1-13  
Screw

Purchased No

Location Loc Qty Loc Code

GA 2  
119736 2  
ST304 42  
119736 42  
ST306 400  
125654 400  
ST506 500  
124326 500

3

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Shop Packet Print

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D2444 PIP PIN

MS27039-1-13 SCREW  
NAS1149D0332J WASHER 3PL  
MS21042L3 NUT

FWD BRACKET  
OUTBD

D2372 QUICK  
RELEASE  
2 PL

D3179-1 LITTER TIE DOWN BRACKET

# **D3179-041 LITTER TIE DOWN BRACKET**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3179-041" ON BOTTOM FACE USING FINE POINT PERMANENT INK MARKER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.79 lbs

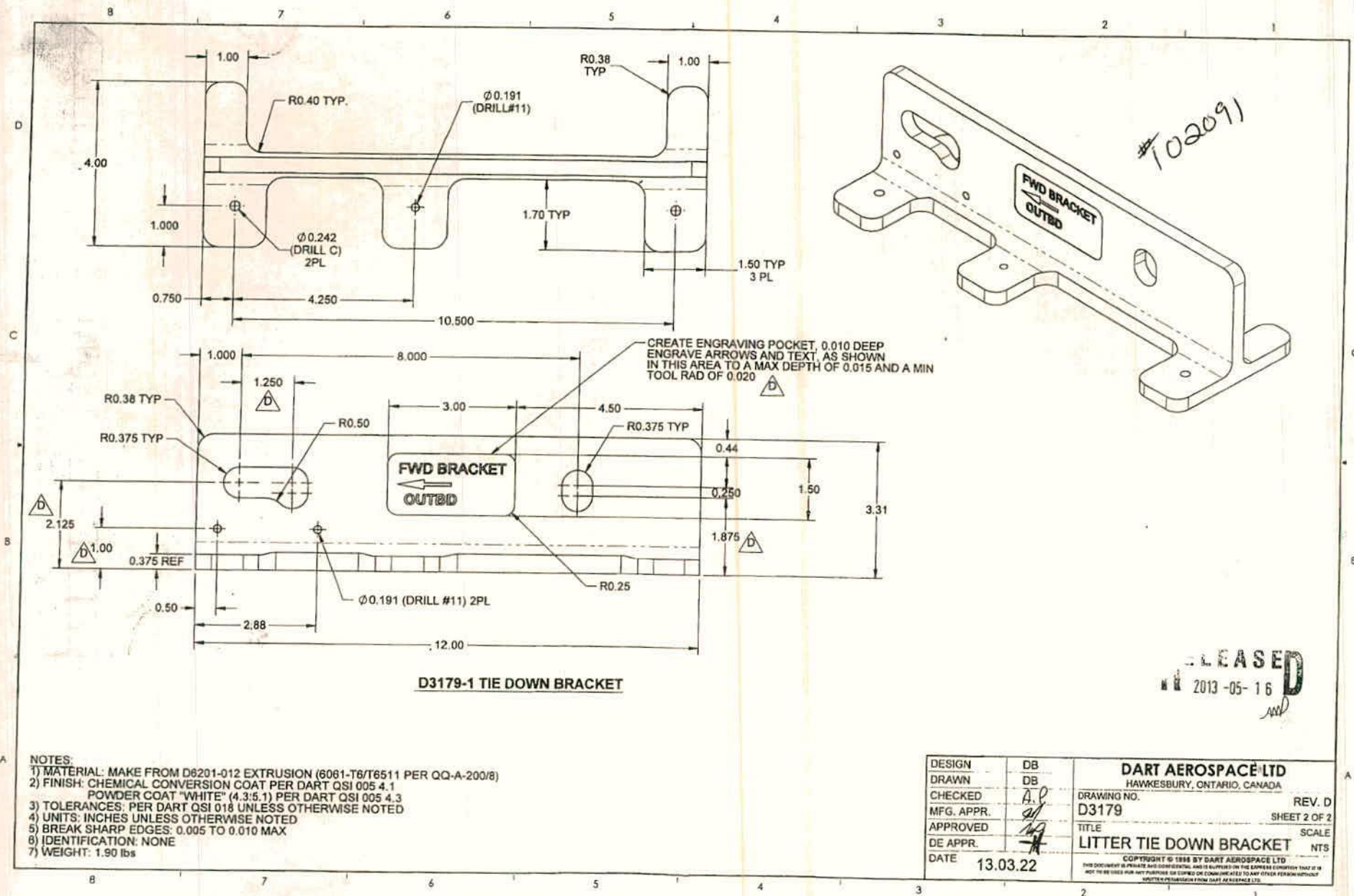
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3179-041	LITTER TIE DOWN BRACKET
1	2	D2372	QUICK RELEASE
2	1	D2444	PIP PIN
3	1	D3179-1	LITTER TIE DOWN BRACKET
4	1	MS21042L3	NUT
5	1	MS27039-1-13	SCREW
6	3	NAS1149D0332J	WASHER (AN980JD10L)

#102091

RELEASED  
2013-05-16

D	POSITION AND SHAPE OF LITTER CAPTURE SLOTS CHANGED (ZN B4-2, B8-2, C7-2), ADD ENGRAVING NOTE (ZN C4-2), REF CIR13-15		DB	13.03.22
C	ADD D3179-041 & PARTS LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N		RF	08.11.07
B	REFORMAT DRAWING, FINISH WAS ANODIZE		DC	07.06.06
A	NEW ISSUE		RF	02.12.09
REV.	DESCRIPTION		BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	A.P.			
MFG. APPR.	2/1			
APPROVED	1/1			
DE APPR.	1/1	REV. D		
DATE	13.03.22	SHEET 1 OF 2		
		SCALE		
		TITLE		
		LITTER TIE DOWN BRACKET		
		NTS		
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	102091
<b>Description:</b> Fwd Litter tie down		<b>Part Number:</b>	3179-1
<b>Inspection Dwg:</b> D3179 <b>Rev:</b> D		<b>Page 1 of 12</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	1.001	✓		vern	RT-4
Ø .191	+ .005/- .001	.193	✓			
1.00	+/- .030	.997	✓			
1.50	+/- .030	1.499	✓			
1.70	+/- .030	1.699	✓		depth gauge	RT-6
10.500	+/- .010	10.500	✓		tape	RT-10
4.250	+/- .010	4.250	✓			
.750	+/- .010	.749	✓			
1.000	+/- .010	1.000	✓			
4.000	+/- .030	3.998	✓			
1.000	+/- .010	.999	✓			
8.000	+/- .010	8.000	✓			
→ 3.00	+/- .030	2.990	✓			
→ 4.50	+/- .030	4.52	✓			
R .375		.3725	✓			
.44	+/- .030	.456	✓			
1.50	+/- .030	1.470	✓			
.250	+/- .010	.244	✓			
3.31	+/- .030	3.315	✓			
1.875	+/- .010	1.868	✓			
12.00	+/- .030	12.000	✓			
Ø.242	+ .005/- .001	.244	✓			
2.88	+/- .030	2.873	✓			

<b>Measured by:</b> JT 02	<b>Audited by:</b> DAS 04 9-83	<b>Preliminary Approval:</b>
<b>Date:</b> 13-05-31	<b>Date:</b> 13.C.3	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

2185

10.04.15

